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OPERATING INSTRUCTIONS
H FRAME PRESSES
STP15,STP-35

English：E1~E4

1. SAFETY PRECAUTIONS

Fail to comply with the following cautions and warnings could cause equipment damage and personal injury.

IMPORTANT : Minimum age of the operator must be 18 years The operator must have read and understood all instructions, safety issues, cautions and warnings before starting to operate the SUN RUN equipment. The operator is responsible for this activity towards other persons.

WARNING : To avoid personal injury and possible equipment damage, make sure all hydraulic components withstand the maximum pressure of 700 bar(10,000psi).

WARNING: Always wear safety glasses. The operator must take precaution against injury due to failure the tool or workpiece.

DANGER: To avoid personal injury keep hands and feet away from cylinder and workpiece during operation.

WARNING : Do not overload equipment. Overloading cause equipment failure and possible personal injury. The cylinders are designed for a max. Pressure of 700 bar (10,000psi).

WARNING: Immediately replace worn or damaged parts with genuine SUN RUN parts. SUN RUN parts are designed to fit properly and withstand rated loads.

IMPORTANT: Hydraulic equipment must only be serviced by a qualified hydraulic technician. For repair service, contact the SUN RUN Service Center in your area. To protect your warranty, use only SUN RUN oil.

DANGER: NEVER set the relief valve to a higher pressure than the maximum rated pressure of the pump. Higher settings may result in equipment damage and/ or personal injury. Do not remove relief valve.

WARNING : The system operating pressure must not exceed the pressure rating of the lowest rated component in the system. Install pressure gauges in the system to monitor operating pressure. It is your window to what is happening in the system.

CAUTION: Avoid sharp bends and kinks that will cause severe back-up pressure in hoses. Bends and kinks lead to premature hose failure.

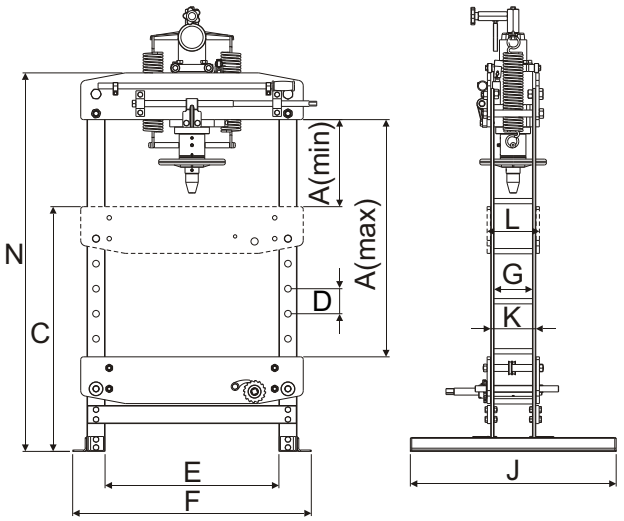
DO NOT drop heavy objects on hose. A sharp impact may cause internal damage to hose wire strands. Applying pressure to a damaged hose may cause it to rupture.

IMPORTANT: Do not lift hydraulic equipment by the hoses or couplers. Use the carrying handle or other means of safe transport.

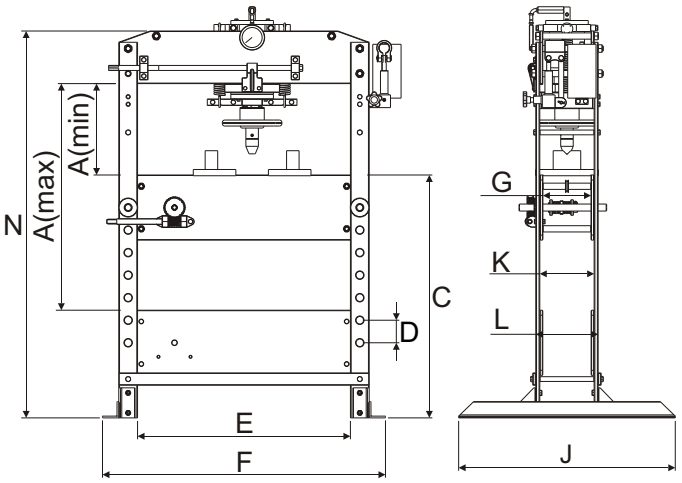
CAUTION : KEEP HYDRAULIC EQUIPMENT AWAY FROM FLAMES AND HEAT. Excessive heat will soften packings and seals, resulting in fluid leaks. Heat also weakens hose materials and packings. For optimum performance do not expose equipment to temperatures of 65^{0}C(150^{0}F) or higher. Protect hoses and cylinders from weld spatter.

DANGER: Do not handle pressurized hoses. Escaping oil under pressure can penetrate the skin causing serious injury. If oil is injected under the skin, see a doctor immediately.

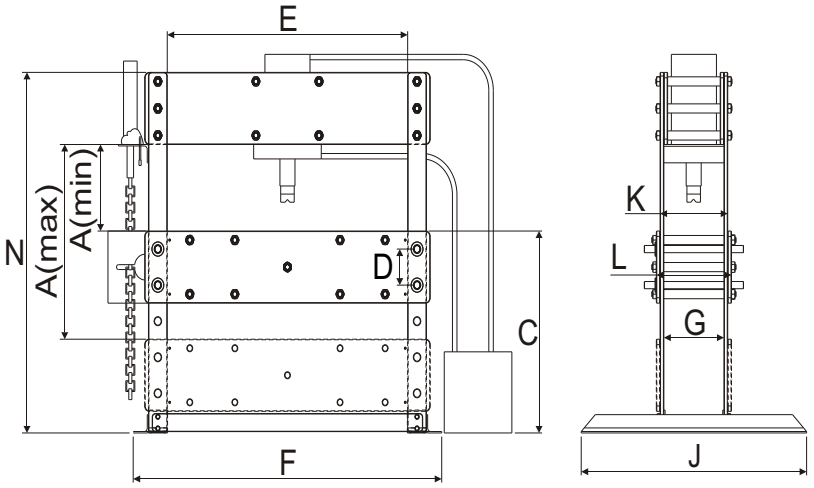
2. Dimensions



STP-15 / STP-15A



STP-35 / STP-35A / STP-35E



STP-100E / STP-60E

Model Number	Cylinder Capacity ton(kN)	Screw Stroke (mm)	Ram Stroke (mm)	Operting Pressure (kgf/cm²)	Press Modal Pump 2)	Output Flow Rate	Dimensions(mm) A (max)	A (min)	C	D	E	F	G	J	K	L	N	Wt. 重量 (kg)
STP-15	15(148)	90	108	300	H	5c.c./once	1000	310	880	90	625	858	138	740	162	188	1510	168
STP-35	35(335)	125	172	360	H	6c.c./once	1085	335	970	90	850	1130	192	865	217	249	1695	220
STP-35AH 1)					A & H	750c.c./min												222
STP-35EH 1)				360	E & H	8750c.c./min												250
STP-60E 1)	60(523)	—	310	70 210	E	8750c.c./min 3000c.c./min	1050	250	1350	100	1050	1380	268	1000	306	338	1900	670
STP-100E 1)	100(1010)	—	300	70 210	E	8750c.c./min 3000c.c./min	1080	480	1120	200	1600	2050	400	1500	450	500	2000	1500

1) STP-35AH：Air pressure7~10kgf/cm² STP-35EH：0.5HP*110/ 220V*1PH STP-60E：3HP*220V*3PH STP-100E：5HP*220V*3PH

2) H:by manual A:by air E:by electric

3. OPERATE

Remove banding from the press and shipping pallet, and remove all cartons. Stand the press upright. Refer to the part list, and follow these instructions during the assembly of hydraulic components and accessories.

1. If your hydraulic presses is with pump ,please check any connect of pump to hydraulic presses and inspect as below:
   Air pressure range : 7~10kgf/cm^2 (fig1)
   Electric Pump :
   STP-35E: 2HP-220V-3PH
   STP-60E: 3HP-220V-3PH
   STP-100E: 5HP-220V-3PH
   *Electric Pump please check again from nameplate.

Fig1

2.Positioning the work bed:

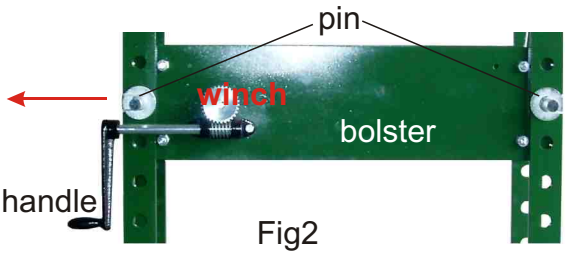


Fig2

2.1 Low bolster(fig2):

A. Put a small amount of tension on the cable by cranking the winch up, taking weight off the pins. This frees the pins in the end of the bolster next to the winch (or right side of the press). Pull the loose pins out.

B. Raise the other end of the bolster by pulling slightly on the handle until the other two pins are free.

C. Crank the winch for either up or down movement of the work bed. Reassemble the pins.

★**As put down STP-15's low bolster, user hand can't leave the winch handle and user foot can't stand under the bolster (Fig2-1).** If user hand leave the handle will cause bolster to fall down sharply.

★ No matter raising or lowering the bolster, must assemble pin from front to back hole completely.

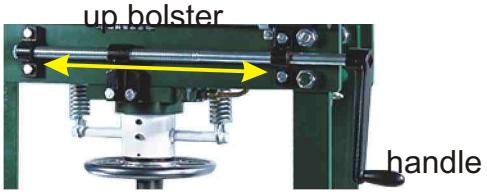
★ When bolster position is ready and support pins are inserted completely then turn a little the winch handle to **release cable**. That because nervous cable maybe broken or make metal fatigue as bolster pressured.

★To prevent cable breakage, never raise or lower the bolster while it holds a load.

★ Inspect the entire length of the lifting cables at least every three months. Replace any cable that appears frayed, worn, or crushed. The cables must run on the pulleys easily, and the pulleys must be free to turn. Careful cable maintenance will help prevent cable breakage.

2. OPERATE(CONTINUE)

fig2-2



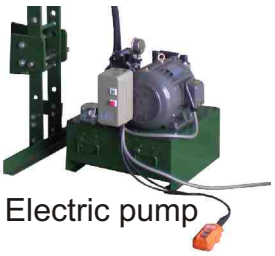
2.2 Up bolster (fig2-2):
Use handle to move plunger to right or left.

2.3 Pump (fig2-3):

A. To inspect all connect with pump and screw release valve.

Manual

Air pump


Electric pump

release valve

fig2-3

oil/ vent cap

B. Inspect oil level and change drilled bolt to be oil/ vent cap before working.
★Inspect the oil at least every three months and fill hydraulic oil R32 till 90% of oil tank.

2.4 Process :

If bolster is at highest position ,but object still can't touch plunger, please use wheel (as fig2-4) to extend plunger.

★ Extened plunger is unsuccessful at high pressure, so we sharply suggest to use other strenuous plate (or V-Blocks) to reduce distance both of plunger and object .

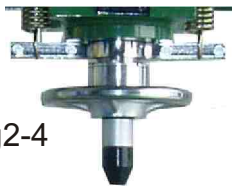


fig2-4

After step2.1~2.3 user can use manual type at first , it will be faster and easy to work. As you fell strenuous to work, you can choose air pump or electric pump type to increase working efficiency.

★ As finish working, should return the plunger completely.